

Description:	S1301-M primer is a specially formulated 100% volume solids (solventless) two component epoxy
Recommended use:	As a epoxy primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. Can be used with Raychem 3 layer coating systems : HTLP80, HTLP60, DIRAX, ROCS60E.
Colour:	Black
Volume solids:	100%
Weight solids:	100%
Mixing ratio:	(by volume) : 3 parts of base (part A) to 1 part of hardener (part B) (by weight) : 5 parts of base (part A) to 1 part of hardener (part B)
Typical coverage:	6.0 sq.m/litre (64.7 sq.ft/litre) or 22.7 sq.m/US gallon (244.5 sq.ft/US gallon). This coverage is based on 100-150 microns or 4-6 mils average thickness.
Specific gravity:	Base : 1.65 Hardener: 1
Typical thickness:	100-150 microns (4-6 mils)
Pot life:	100 min at 23°C, 25 min at 40°C
Shelf life:	2 years 23°C (73°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.
Flash point:	Base : 143°C (289°F) Hardener: > 118°C (244°F)
Thinner:	Do not dilute
Application	<ol style="list-style-type: none">1. Prepare the pipe surface as recommended in the product application guide2. Pour hardener into base as per mixing ratio. Stir the mixture for approximately 1 minute to ensure a homogeneous mixture.3. Carefully apply mixed epoxy primer as indicated in the product application guide.
Ordering info:	Epoxy kit : S1301-M-KIT-1.4SQM-15SQFT This kit includes measured quantities of base resin and hardener, a stirring stick, applicator pad and gloves. This kit contains sufficient primer for up to 1.4 SQM (15 sqft) of coverage. Bulk Epoxy: Base : S1301-M-PART-A-18L-4.75GAL Hardener: S1301-M-PART-B-18L-4.75GAL Always order in multiples of 3 pails of part A by 1 pail of part B For accessories to apply epoxy see DS-ACCESSORIES-REV-4-08-03

Epoxy usage (assuming 300 mm / 12" cutback)

Pipe diameter		Quantity required		# Joints / US gallon	# Joints / Litre
		base	cure		
DN	inches	ml	ml		
80	3.500	10.6	3.5	267	70
100	4.500	13.7	4.6	207	54
150	6.625	20.1	6.7	141	37
200	8.625	26.2	8.7	108	28
250	10.750	32.6	10.9	87	22
300	12.750	38.7	12.9	73	19
350	14.000	42.5	14.2	66	17
400	16.000	48.6	16.2	58	15
450	18.000	54.6	18.2	51	13
500	20.000	60.7	20.2	46	12
550	22.000	66.8	22.3	42	11
600	24.000	72.8	24.3	38	10
650	26.000	78.9	26.3	35	9
700	28.000	85.0	28.3	33	8
750	30.000	91.1	30.4	31	8
800	32.000	97.1	32.4	29	7
850	34.000	103.2	34.4	27	7
900	36.000	109.3	36.4	25	6
950	38.000	115.3	38.4	24	6
1000	40.000	121.4	40.5	23	6

Epoxy required for 300 mm / 12" cutback.

For other cutbacks, divide by 12 and multiple by new cutback in inches

Example: 200 mm (8") cutback on a DN400 diameter pipe

Base : 48.6 ml x 8/12 = 32.4 ml

Hardener : 16.2 ml x 8/12 = 10.8 ml



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